

# Work Order ID 52280-1

Tuesday, September 22, 2009 1:26:42 PM

Page 1

Item ID: D2530 *BK* *Split - 1* *Schultz* Accept

Revision ID: B

Item Name: Handle Weldment

Start Date: 9/23/2009 Start Qty: *10.00*

Required Date: 10/2/2009 Req'd Qty: *10.00*

Reference:

Approvals: Process Plan: *PL MW* Date: *09-22* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2530	Rev B
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100



Small Fab

Small Fab

Small Fab

Memo

1-Cut to length as per Dwg D2536 □ 2-Deburr

0.00

0.00

*M. L. Schultz*

*(10X)*

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*2) Schultz*

*(40)*

*4*

120



Small Fab

Small Fab

Small Fab

Memo

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 □ 2-Deburr

0.00

0.00

*24 09/10/05*

*(5X)*

*(P10) →*

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Handwritten text, possibly a signature or name, located in the lower left quadrant of the page.

W/O: 52280

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		cup was split for 5 due to missing parts	S	2/10/7	5		S 02/10/07

Part No: D2530 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Work Order ID 52280

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Item ID: D2530

Accept



Setup Start



Revision ID: B

Stop



Item Name: Handle Weldment

Start Date: 9/23/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

10 09.10.07 5

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 5 09/10/07

5

φ

Quality Control

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

11/09/09 09-10-9

5

Powder Coating

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30





**Work Order ID 52280**

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Item ID: D2530

Accept



Setup Start



Revision ID: B

Stop



Item Name: Handle Weldment

Start Date: 9/23/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

HL 09/10/09

45 0

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: sub

0.00

P 09/10/09 (5)

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/10/13

MF 09-10-09

Memo

0.00





# Picklist Print

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Work Order ID: 52280



Parent Item: D2530RevB



Parent Item Name: Handle Weldment

Start Date: 9/23/2009

Required Date: 10/2/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2534RevD		Manufactured	No			100	Each	10.0000	20.0000			



Lock Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

47176

10

M304TR0.750W.049

Purchased

No

120

f

286.3500

30.6789



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

286.35

107518

2.77

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

112652

253.89

10x 14 09/10/02

m-t 09/10/01  
M112800



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. B
		D2530	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

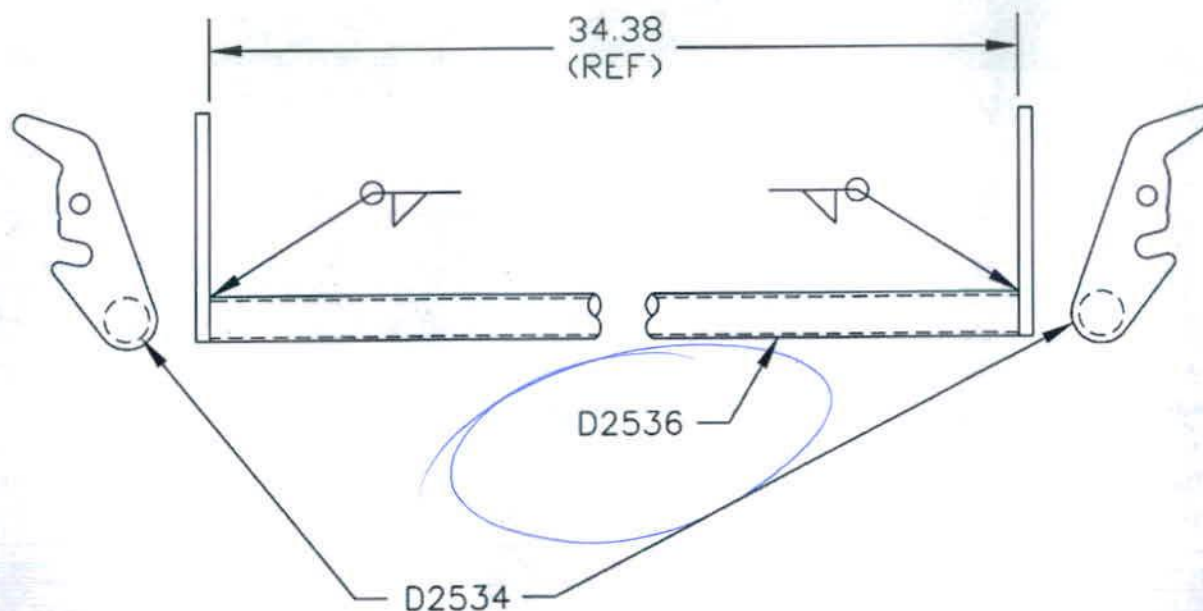
RELEASED

04.12.16 *[Signature]*

## PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENTS  
WITHOUT NOTICE  
WORK ORDER  
NO. 52290

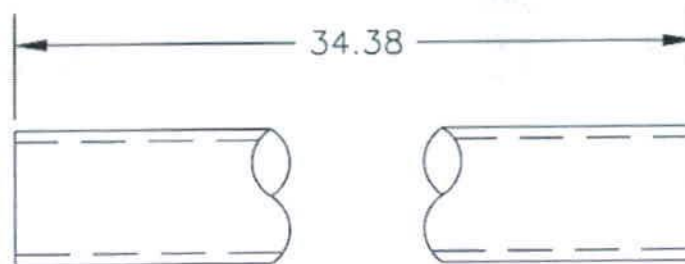
D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2536	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		HANDLE	NTS
A	96.05.15	NEW ISSUE	
B	04.12.14	UPDATE NOTES	

**RELEASED**04.12.16 *[Signature]***REFERENCE ONLY***\$22.80***D2536 HANDLE**

- 1) MATERIAL: AISI 304/316 SS  $\phi 0.75$  X 0.049 WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries